

Page 1

Friday, August 26, 2011 10:30:11 AM D3246-041 Item ID: Accept Setup Start **Revision ID:** Stop Item Name: Mounting Bracket Start Qty: 6.00 **Start Date:** 8/26/2011 **Cust Item ID:** Req'd Qty: 6.00 Required Date: 9/9/2011 **Customer:** Reference: Run Start CX Date: 1/68/24 Tooling: **Process Plan: Approvals:** Date: Stop Date: _____ QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code **Oty** Otv Number Stamp **Draw Nbr Revision Nbr** D3246 Rev A1 100 0.00 FLOW WATER JET BIL 8-31 Waterjet 0.00 Memo □Dwg Rev: A\ □Prog Rev: A\ FLOW CNC Waterjet 1-Cut as per Dwg Dsi9279 Deburr if necessary 2624,050 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1311-8-31 QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check

OC

Quality Control

1/02/31

Memo

| | - CP - C | | | | | | | | | |
|---------|----------|-------------------|----------------------|------------------------------|----------|----------------|--------------|--------|-------------------------------------|--------------------------|
| W/O: | | WO | RK ORDER CHAN | GES | - | | | • | ; | |
| DATE | STEP | PRO | OCEDURE CHAN | IGE | | Ву | Date | Qty | Approvál Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | | |
| | | | | | | | | | | |
| Part No | : | PAR #: | Fault Categ | ory: | NCI | R: Yes | No DQ | A: | Date: _ | |
| | Re | esolution: | Disposition | : | QA | N/C CI | osed: | | Date: _ | <u></u> |
| NCR: | | | WORK ORDE | R NON-CONFORM | MANCE | (NCR |) | | | |
| | | Description of NC | | Corrective Action Se | ection B | | Verific | cation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | 1 | Sign & Date | | on C | Chief Eng | QC inspector |
| | | | | | | | | | | |
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Friday, August 26, 2011 10:30:11 AM

Item ID:

D3246-041

Accept

Setup Start



Revision ID:

Item Name:

Mounting Bracket

Start Date:

Required Date: 9/9/2011

8/26/2011

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Tool # Plan

Date:

Run

Reject

Oty

Start Stop

Stop



Insp.

Stamp

Reject

Number

Sequence ID/

Work Center ID

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Deburr□Form as per Dwg D3246□C'sink as per Dwg D3246

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Code

Accept

Otv

150

HandFinish

Hand Finishing

Memo

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

| Dart Ae | rospace | e Ltd | | | | | | | |
|---------|---------|-------------------|----------------------|------------------------------|--------------|-------|------------|-------------------------------------|--------------------------|
| W/O: | | | W | ORK ORDER CHANG | ES | | | | |
| DATE | STEP | PRO | PROCEDURE CHANGE | | | | | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| Part No | : | PAR #: | Fault Cat | egory: | _ NCR: Yes | No DQ | A : | Date: _ | |
| | R | esolution: | Dispositi | on: | _ QA: N/C CI | osed: | | Date: _ | |
| NCR: | | | WORK ORI | DER NON-CONFORMA | NCE (NCR |) | | | |
| 5475 | 0750 | Description of NC | Corrective Action | | , | | cation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | ion C | Chief Eng | QC Inspector |
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Friday, August 26, 2011 10:30:11 AM



Page 3

Item ID:

D3246-041

Accept



Setup Start



Revision ID:

Item Name:

Mounting Bracket

Start Date:

8/26/2011

Start Qty: 6.00

Required Date: 9/9/2011

Req'd Qty: 6.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling: SPC (Y/N):

Set Up/

Run Hours

Date: Date:_ Run

Start

Stop

Stop



Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC3-Inspect Part Finish

Memo

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

BR 11-11-10.

170

Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

Install Nut Plates as per Dwg D3246

180

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

| Duit Aci | ospase | - Ltd | | | | | | | |
|-------------|--------|-------------------|----------------------|------------------------------|-----------------|-----------------|--------|-------------------------------------|--------------------------|
| W/O: | | | WC | RK ORDER CHANG | ES | | | | |
| DATE | STEP | PRO | PROCEDURE CHANGE | | | | | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | | |
| Part No | • | PAR #: | Fault Cate | gory: | _ NCR: Yes | s No DQ | A: | Date: _ | |
| | Re | esolution: | Disposition: C | | | QA: N/C Closed: | | | |
| NCR: | | | WORK ORDI | ER NON-CONFORMA | NCE (NC | R) | | | |
| DATE | STEP | Description of NC | | | Section B Verif | | | cation Approval | |
| DAIL | JILF | Section A | Initial Chief Eng | Action Description Chief Eng | Sigr Dat | | tion C | Chief Eng | QC Inspector |
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Work Order ID 73245

Friday, August 26, 2011 10:30:11 AM



Page 4

Item ID:

D3246-041

Accept



Setup Start

Stop



Revision ID:

Mounting Bracket Item Name:

Required Date: 9/9/2011

Start Date:

8/26/2011

Start Qty: 6.00

Req'd Oty: 6.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:_____ SPC (Y/N): Date:

Tool# Plan

Stop

Sequence ID/ **Work Center ID**

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Set Up/ **Run Hours**

0.00

0.00

Code

Accept Qty

Reject Qty

Reject Insp. Stamp Number

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

| | | — - | | | | | | | |
|---------|------|-------------------|----------------------|------------------------------|----------------|--------------|-------------------------------|--------------------------|--------------|
| W/O: | | | WC | RK ORDER CHANGE | S | | | | |
| DATE | STEP | PRO | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| Part No | : | PAR #: | Fault Cate | gory: | NCR: Yes | No DQ | A: | _ Date: _ | |
| | Re | esolution: | Dispositio | n: | QA: N/C Clo | osed: | | Date: _ | ****** |
| NCR: | | | WORK ORDI | ER NON-CONFORMA | NCE (NCR |) | _ | | |
| DATE | STEP | Description of NC | | | ection B | | cation | Approval | Approval |
| DAIL | SILF | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Sect | ion C | Chief Eng | QC Inspector |
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Picklist Print

Friday, August 26, 2011 10:30:09 AM

Work Order ID: 73245

Parent Item:

D3246-041

Parent Item Name: Mounting Bracket



Start Date: 8/26/2011

Required Date: 9/9/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 06-06-22 JLM

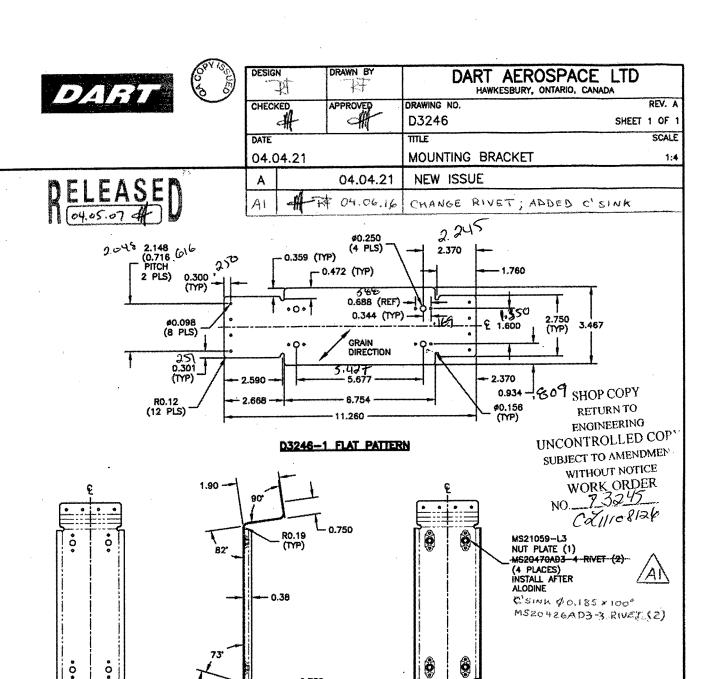
| Component Item ID/ tem Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Status Issued |
|--------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|-------------------------|
| AS21059L3 | | Purchased | No | | | 110 | Each | -264.0000 | 4 | 24 | | ho |
| | | | | Location | <u>1</u> | Loc (| <u>Oty</u> | Loc Code | | | | |
| | | | | ST301 | | | 258 | | | | | |
| | | | | | 118234 | | 58 | | _ | | _ | |
| | | | | | 118614 | | 200 | | | 28 | _ | |
| • | | | | ST302 | | | 6 | | | | _ | |
| | | | | | 116706 | • | 6 | | _ | | <u>.</u> | |
| A2024T3S.050 | | Purchased | No | | | 170 | sf | 95.9000 | 0.3097 | 1.956 | | ۲٤٠ |
| 2024-T3 .050 sheet | | | | | | | | | | | B11-8-3 | 31 |
| | | | | Location | <u>1</u> | Loc | <u>Otv</u> | Loc Code | | - | | $\langle \zeta \rangle$ |
| , | | | | MAT22 | | | 95.9 | | | | | (I) |
| | | | | | 117684 | | 95.9 | • | | 17684 | - | • |
| MS20426AD3-3 | | Purchased | No | ř | | 170 | Each | 1,797.000 | 8 | 48/ | 1 | / / |
| Livet | | | | | | | | • | | | 21// | 1/10 |
| | | | | Location | <u>n</u> | Loc | Qty | Loc Code | | // | / ' | |
| • | | | | ST316 | | | 1797 | | | | | |
| | | | | | 19099 | | 1797 | | | 56 | - | |

| W/O: | | | WO | RK ORDER CHANG | ES | | | | |
|---------|------|--------------------------------|--------------|--|------------|--------------|------------------------|-------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CHAN | IGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | • | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| Part No | : | PAR #: | Fault Cated | orv: | NCR: Yes | No DQ | A: | Date: | |
| | | esolution: | | | | | | | |
| NCR: | | | WORK ORDE | R NON-CONFORMA | ANCE (NC | R) | | | |
| DATE | STEP | Description of NC Section A | Initial | Corrective Action Section Action Description | ion B Sign | | Verification Section C | | Approval QC Inspector |
| | | Jection A | Chief Eng | Chief Eng | Date | | | Chief Eng | QO IIISPECIOI |
| | | | | | | | | | |
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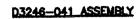
| DART AEROSPACE LTD | Work Order: | 73245 |
|-------------------------------|--------------|-------------|
| Description: Mounting Bracket | Part Number: | D3246-1 |
| Inspection Dwg: D3246 Rev: A1 | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| | x | First Article | | Protot | | |
|----------------------|---------------------|------------------|-------------|--------|-------------------------|----------|
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
| Ø0.098 | +0.004/-0.001 | .10(| 7 | | V BOZ | |
| Ø0.250 | +0.005/-0.001 | 929 | 7 | | V | |
| 11.260 | +/-0.010 | 11.768 | ≽ | | T BOI | |
| 6.754 | +/-0.010 | 6.756 | <i>></i> | | V | |
| 5.677 | +/-0.010 | 5.679 | > | _ | V | |
| 2.668 | +/-0.010 | 2, 400 | > | | V | |
| 3.467 | +/-0.010 | 3,473 | 7 | | V | |
| 2.750 | +/-0.010 | 3,755 | 7 | | V | |
| 2.370 | +/-0.010 | 2,377 | > | | V | |
| 0.472 | +/-0.010 | 417 | 9 | | V | |
| 0.359 | +/-0.010 | 356 | 7 | | V | |
| 0.300 | +/-0.010 | .299 | X | 1 | V | |
| 0.301 | +/-0.010 | 353 | 9 | | V | |
| | | | | | | |
| Measured by: | · | Audited by: | 7 | | Prototype Appro | |
| Date: ((| -8-3 | Date: | 11/08/3/ | | | ate: N/A |
| | Change New Issue | P/O D3246-04 | 1 | | Revised KJ/EC/D | |



D3246-1 BEND DETAIL



3.00 (REF)

NOTES:

Ö

1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

0.750

90

ALL DIMENSIONS ARE IN INCHES BREAK ALL SHARP EDGES 0.005 TO 0.010